

Date: Monday, 18/08/2008 4:04:07 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE AND LOCK- DOWN ASSY
 Job Number : 41353
 Estimate Number : 13525
 P.O. Number :
 This Issue : 18/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 18/08/2008 Type : LARGE FAB ASSY
 Previous Run : 41064
 Part Number : D3451043
 Drawing Number : D3451 REVA
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 18/09/2008 Qty: 2 ~~4~~ Um: Each
 Written By :
 Checked & Approved By : JL008-8-18
 Comment : Est Rev:A 08-06-27 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34513 Tube Handle Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s)
 Tube Handle Arm
 batch: 41460 MF 08-10-17

2.0 GP211 Rubber Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Rubber Handle
 batch: M108992 MF 08-10-17

3.0 PB6743001103 Tube Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Tube Handle
 batch: B41364 MF 08-10-17

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1- weld as per dwg PB67-43001

SP 08.10.16 (2x)

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL08-10-17
 BE 08-10-17 (2x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:04:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE AND LOCK- DOWN ASSY

Job Number: 41353

Part Number: D3451043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/17 (X2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/10/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
320 OF
3:45

M-L 08/10/17

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 08/10/20 (2)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

E 08/10/20 (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/20 (X2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 512

S/L 10/20

(2)

30

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/21

M-L 08-10-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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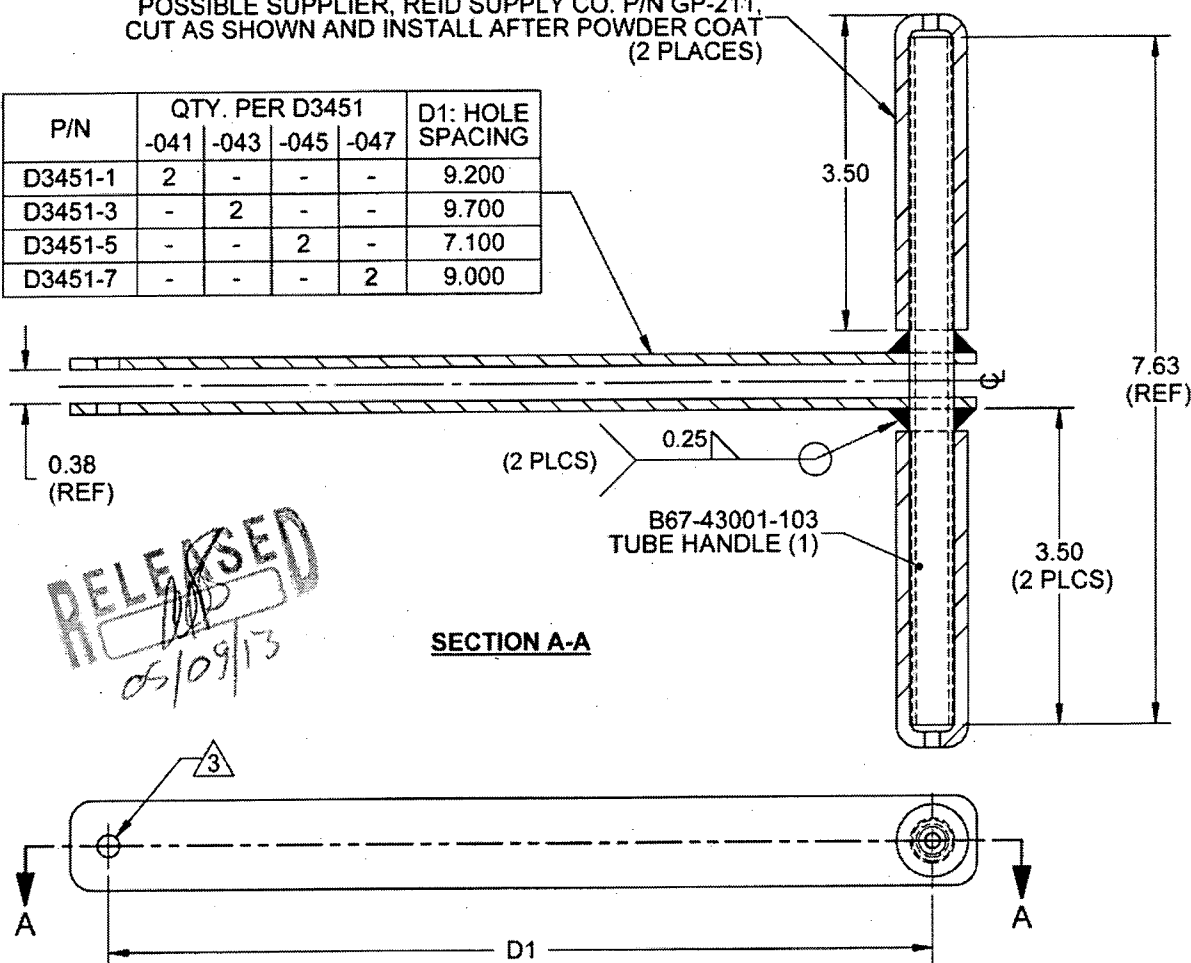
NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|-------------------------|--|------------------------|
| DESIGN [Signature] | DRAWN BY [Signature] | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3451 | REV. A SHEET 1 OF 2 |
| DATE 05.08.25 | | TITLE HANDLE & LOCK-DOWN ASS'Y | SCALE 1:2 |
| A | 05.08.25 | NEW ISSUE | |

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211.
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

| P/N | QTY. PER D3451 | | | | D1: HOLE SPACING |
|---------|----------------|---|---|---|---------------------|
| D3451-1 | 2 | - | - | - | 9.200 |
| D3451-3 | - | 2 | - | - | 9.700 |
| D3451-5 | - | - | 2 | - | 7.100 |
| D3451-7 | - | - | - | 2 | 9.000 |



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

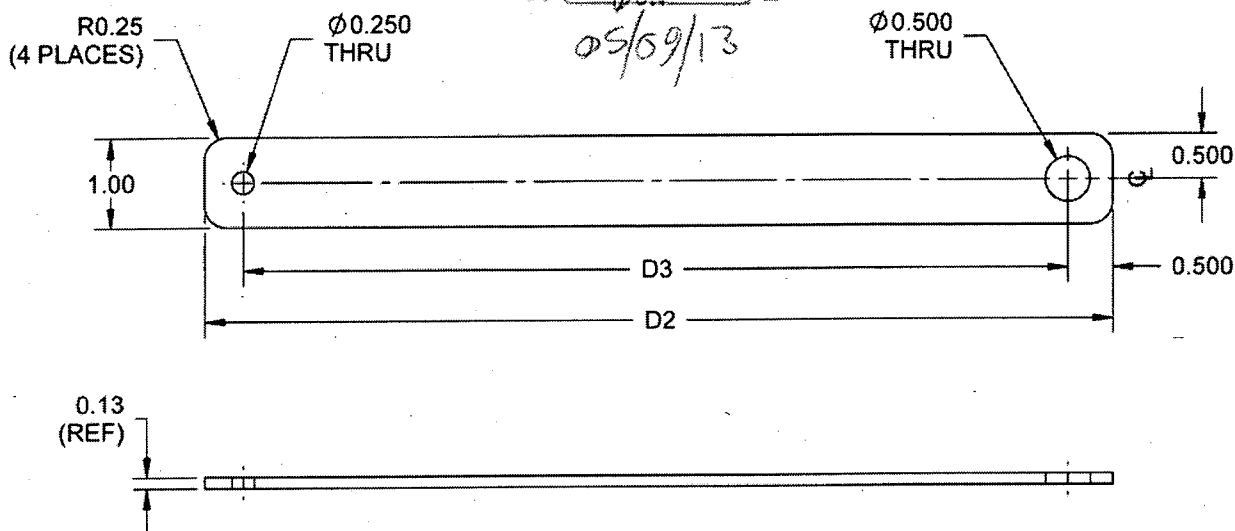
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WORK ORDER
NO. **41353**

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DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3451 | REV. A SHEET 2 OF 2 |
| DATE 05.08.25 | | TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2 | |

RELEASED
[Signature]
05/09/13

| P/N | D2: CUT LENGHT | D3: HOLE SPACING |
|---------|----------------|------------------|
| D3451-1 | 10.25 | 9.200 |
| D3451-3 | 10.63 | 9.700 |
| D3451-5 | 8.00 | 7.100 |
| D3451-7 | 10.00 | 9.000 |

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303
D3451-5 SUPERSEDES PREMIER P/N B67-43001-301
D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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